DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-011761
Date Inspected: 22-Jan-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Xu Xian Ping

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Sub-Assembly

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

Non-Destructive Testing:

Ultrasonic Testing (UT) pursuant to NDT Inspection Notification Sheet(s) (Document No. 005116, 005117, 005110 AND 005108):

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. 10TR1-025-001, 005, 007, 014
2. 11TR5-004-001, 005, 007, 014
3. 11TR9-002-001, 005, 007, 014
4. 11TR5-007-001, 005, 007, 014
5. 11TR9-001-001, 005, 007, 014
6. USPL1-265-001, 002
7. USPL1-272-001, 002
8. USPL1-274-001, 002
9. USPL1-280-001, 002
10. 13TB90-001, 002
11. 13TB65-001, 002
12. 13TB95-001, 002
13. 13TB29-001, 002

Magnetic Particle Testing (MT) pursuant to NDT Inspection Notification Sheet(s) (Document No. 005116):

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. 13TB90-001, 002 2. 13TB65-001, 002 3. 13TB95-001, 002 4. 13TB29-001, 002

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10250 (for ZPMC UT Reject) of 10TR2-016; Weld 014. Welder is identified as 045240. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10271 (for ZPMC UT Reject) of 10TR1-023; Weld 014. Welder is identified as 045227. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10268 (for ZPMC UT Reject) of 10TR3-003; Weld 014. Welder is identified as 045227. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10248 (for ZPMC UT Reject) of 10TR2-022; Weld 014. Welder is identified as 045240. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10280 (for ZPMC UT Reject) of 10TR1-018; Weld 014. Welder is identified as 045227. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10274 (for ZPMC UT Reject) of 11TR1-013; Weld 014. Welder is identified as 045240. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

WELDING INSPECTION REPORT

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Holmes,Stefan	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer